Work Orde June-16-14 1:16		1117		*12	1117*						Page 1	
Item ID: Revision ID: Item Name:	D3404-1 GHW/ Lug			Accept	*N900	040	100)* s	etup Star Stop	· · · · · ·	S1* S2*	Personal Per
Start Date: Required Date: Reference:	6/16/14 : 6/16/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:				4	·	
Approvals:		nn: <u>MU</u> 5	Date: 14-06-18	Tooling: SPC (Y/N):		ate:		R	tun Star Stop	~I <i>V</i> I	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr			,	<u>)</u>						_
D3404	Rev	C			فو	1						
100		BAND SAW			ort 14/0	07/01		40			-	· .
Bandsaw Jeaspa Bandsaw		Memo Cut blank: 2	.700" long	0.00								
110				0.00						ė.		
110 HAAS 1		HAAS CNC VERTICAL	MACHINING #1	0.00				<u>40</u>	<u>\$</u>		DAS 64	.07.0
HAAS CNC vertica	ıl machine #1	Memo 1-Machine a Ai3 2-1	s per Folio FA555 and Dwg Deburr		Folio Rev:			• ,			37 9-89	
120		QC2- Inspect parts off ma	achine FAI/FAIB	0.00								
120 QC Quality Control		Memo		0.00				40	_ø	· ·	→BAS / ' 37 9-89	4.07.a

DQA:			Date:											
QA Closed:			Date:			WORK ORDER	R NON-	-CO	NFO	RMANCE / UPDATE	۱۸/	ork Order up	ndata only	AEROSPACE
QA Closed.			Date.								V V	ork Order up	date only	
Work Orde	er:					DISPOSITIO	N			AGAINST	r de	PARTMENT	/PROCESS	
						Rev	vork 🗌	1		Skid-tube Crosstube	•]	Water Jet	Engineering
Part N	lo					S	crap	1	I	Machining Small Fab	\Box	Pro	d. Eng. Coor.	Quality
						Use-	asis]	Thern	noforming Finishing	3	Rec/Sto	re/Packaging	Other
NCR N	lo				_	Suspected Unappro	oved]		Large Fab Composite			Supplier	
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Cause	D	ate	Step	Qty		or non-conformance	•	Chie	ef Eng	Description		Date	Verification	QC Inspector
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26-4	 -		Strip in	Tube	—	Drawing		-	∕isreac		_		·	
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		ning Sec				Finish		$\boldsymbol{\vdash}$		Calibration				
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H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde June-16-14 1:18		21117			*121	117*						Page 2
Item ID: Revision ID:	D3404-1			F	Accept	*N900	040	100)* s	etup Sta	171	S1*
Item Name:	GHW/ Lug	_								Sto	φ * Ν	S2*
	6/16/14	Start Qty: 40.00	*/	4 0 *		Cust Item I	D:					
Required Date:	6/16/14	Req'd Qty: 40.00	*/	40*		Customer:		•		ı		
Reference:									_	G.		
Approvals:	Process Pl	an:	Date:		Tooling:	Da	ate:		R	tun Sta	<i>^</i> I <i>V</i> I	R1*
i	QC:	•	Date:		SPC (Y/N):	Da	ate:			Sto	, *V	R2*
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
*130 *130*		QC8- Inspect parts - secon	nd check	· ′c	0.00				40	Ø		40 9-89
QC		Memo			0.00							14/67/01
Quality Control								•				11/01/01
140		Identificas mandus & Sta	ak Laastians (1	11/0-1831	0.00	•		į.				
		Identify as per dwg & Sto	ск госаноп: <u>Г</u>	· //FW	0.00			(<u>.</u>		9 ·100	2.20
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Packaging								,	(a)	٤.	•.	

1.50

QC21- Final Inspection - Work Order Release

0.00

Memo

Quality Control

0.00

MLJ 1407-10 MF7-10

DQA:			Date:											JART
QA Closed:			Date:			WORK ORDE	RNON	-CC	NFO	RMANCE / U		ork Order up	odate only	AEROSPACE
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NCR I	No		· •			Use Suspected Unappr	roved		Therr	noforming Large Fab	Finishing Composite		e/Packaging Supplier	Other
Root		•			Desci	ription of work order	update	l l	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformanc	e	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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June-16-14 1:18:50 PM

Work Order ID: 121117

121117

Parent Item:

D3404-1

D3404-1

Parent Item Name: GHW/ Lug

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.09.01New issueKJ/JLM

IPP rev B 09.01.28 new geometry rev.C

EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304B0.750X2.500		Purchased	No		100	f	29.1000	0.2291	10		•
N/304B0	750Y2 F	500						**			Ť

304 BAR .750 X 2.50

Location	Loc Qty	Loc Code
MAT007	29.1	
M128496	3.1	
13 M129240	12.667	
27 - M129287	13.333	9

DQA:			Date:												T
04.61			D-4			WORK ORDE	RNON	-COI	NFO	RMANCE / UPDATI			.	AEROSP	ACE
QA Closed:			Date:								w	ork Order u	odate only		
Work Ord	er:					DISPOSITIO	N			AGA	AINST DE	PARTMENT	/PROCESS		
	•					Re	work	1 l		Skid-tube Cros	stube	7	Water Jet	Engineering	
Part i	۷o.						Scrap	11		Machining Sma	all Fab	Pro	d. Eng. Coor.	Quality	
						Use	-as-is]	Thern	noforming Fini	ishing	Rec/Sto	re/Packaging	Other	
NCR I	۷o.		-			Suspected Unappr	oved]		Large Fab Comp	posite]	Supplier		
Root					Desc	ription of work order	ubdata	l	itial	Action		Sign &			
Cause		Date	Step	Qty	Desci	or non-conformanc	7		f Eng	Description		Date	Verification	n QC Inspect	or
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	Ш	Cracks			<u> </u>	Broken/Damage/De	fect	$\boldsymbol{\vdash}$	lardwa			Part Incorre	-	Temperature/Cu	ıre
		Crimp/Kir	nk/Ripple,	/Wave	<u> </u>	Burrs			-	ion Incomplete/Unqualifie	:d	Part Lost/M	ssing	Weld	
	-	Cuffs				Contamination				ions Incomplete/Unclear		Part Moved	L	Wrong Stock Pu	lled
	-	Crushing				Countersink		-	_	ned/off center	\vdash	Positioned V	· ·	— _]	
	Н	Heat Trea				Cut Too Short		-	⁄lislabe		L	Power Loss/	Surge [Other	
, ·	\vdash	Inspectio	· -	l'ube	<u> </u>	Drawing		\mathbf{H}	/lisreac						
•	\vdash	Marks/Ch			<u> </u>	Drill Holes	,e	-	off-set						
	Н	Turning S			<u> </u>	Finish		-		Calibration					
	1 1	Wave/Tw	rist in Tub)e		Fit/Function		1 10	or S	Sequence					

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DART AEROSPACE LTD	Work Order:	121117
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	513			9-Ph	
R0.65	+/-0.030	650			YRIN	JL-10
0.125	+/-0.010	-128			~	
0.500	+/-0.010	-500			~	·
2.14	+/-0.030	2.143			H-Gx	
1.30	+/-0.030	1.36			Jern	_
R2.30	+/-0.030	230				
1.14	+/-0.030	1.142			_	
2.58	+/-0.030	2.578			_	

Measured by: Audited by: 40 Prototype Approval: N/A

Date: 4-7-2 Date: 14/07/04 Date: N/A

1 20 04 40 14		
A 06.04.12 New Issue	KJ/JLM , N	11/1
B 09.05.04 Dimensions updated per D	wg Rev. C KJ/DD	Chil

D3404-1 GHW LUG

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 121117 MCJ

14-06-18

$\overline{}$									
С	I STANDA	RDS AND TR	IN SOLIDWORKS WITH CURRENT ANSFERED TO "B" SIZE BORDER. 1.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02				
В	UPDATE	M-SPEC		PH	05.06.14				
Α	NEW IS	SUE		PH	05.03.08				
REV.			DESCRIPTION	BY	DATE				
DESIG	N	PH	DART AEROSP	ACE L	TD				
DRAW	N	AUS		HAWKESBURY, ONTARIO, CANADA					
CHEC	KED	_ A	DRAWING NO.		REV. C				
MFG. A	APPR.		D3404		SHEET 1 OF 2				

TITLE APPROVED **GHW LUG** DE APPR. COPYRIGHT © 2005 BY DART AEROSPACE LTD
THIS GOCIAMENT'S PRINKE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERS. DATE 08.12.02

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

5

SCALE

NTS

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